

Date: Monday, 06/10/2008 11:18:43 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : MECHANICAL GROUND HANDLING WHEEL KIT
Job Number : 42461A	
Estimate Number : 12136	
P.O. Number :	
This Issue : 06/10/2008 S.O. No. :	Part Number : D206731041
Prsht Rev. : NC	Drawing Number : DSK 093 REV B
First Issue : // Type : MACHINED PARTS	Project Number : N/A
Previous Run : 36615A	Drawing Revision : B
	Material :
Written By :	Due Date : 31/10/2008 Qty: 1 Um: Each
Checked & Approved By : <u>JD 08.10.06</u>	
Comment : est rev. A 01.02.01 new issue EC	
Est Rev:B As per Rev B 07-02-13 JLM	
est rev C 07.05.14 rev C IIN Ec	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D33355	spring
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 pick:

qty	Part Number	Description	batch
1	D3335-5	spring	B33948 ✓

Pl 08.12.05

2.0	D3353041	Lug Weldment
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 LUG ARM WELDMENT
 Batch: B31665 ✓

Pl 08.12.05

su

3.0	D3354041	Left Arm Weldment
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 pick:

qty	Part Number	Description	batch
1	D3354-041	Left Arm Weldment	B34213 ✓

Pl 08.12.05

su

P10

4.0	D3354043	Right Arm Weldment
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 RIGHT ARM WELDMENT
 batch: B36189 ✓

8/10/08

Q

su

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D206-731-041 PAR #: NA Fault Category: Prod/Packaging NCR: (Yes) No DQA: D Date: 08/12/10
 Resolution: Rework Disposition: Re-work QA: N/C Closed: D Date: 08/12/10

NCR: <u>42461A</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08-11-28</u>	<u>3</u> <u>4</u>	<u>The D3354-041 & -043</u> <u>have alot of tiny chips</u> <u>on them exposing the steel.</u> <u>RC: Damaged from stocking &</u> <u>storage. * Heavy solid parts*</u>	<u>[Signature]</u> <u>08/11/2</u>	<u>Grinded out the marks</u> <u>smooth.</u> <u>Re-Powder coat red per specs</u> <u>and chg.</u> <u>Ensure to stock wrapped</u> <u>up in alot of foam.</u>	<u>[Signature]</u> <u>08/12/01</u> <u>[Signature]</u> <u>08/12/01</u> <u>[Signature]</u> <u>08/12/02</u>	<u>[Signature]</u> <u>08-12-02</u>	<u>[Signature]</u> <u>08/11/2</u>	<u>[Signature]</u> <u>08-11-28</u>

NOTE: Date & initial all entries

Date: Monday, 06/10/2008 11:18:43 AM
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Job Number: 42461A

Part Number: D206731041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	D33561	Pin
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	D3356-1	pin	B36640 ✓

Pl 08.12.05 *SD*

6.0	D3397041	Wheel Assembly
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

pick:

qty	Part Number	Description	batch
2	D3397-041	Wheel ass'y	36529 ✓

Pl 08.12.05 *SD*

7.0	113800	GREASE FITTING
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	113-800	GREASE FITTING	M101058 ✓

Pl 08.12.05 *SD*

8.0	656051	flat washer
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

pick:

qty	Part Number	Description	batch
2	656-051	flat washer	M105735 ✓

Pl 08.12.05 *SD*

9.0	663079	Inventory
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	663-079	Lock washer	M16362 ✓

8/10/13

SD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

AN523A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
pick:

qty	Part Number	Description
1	AN5-23A	Bolt

batch

M19278 ✓

PL08.12.05 SP

11.0

AN960JD516

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
pick:

qty	Part Number	Description
1	AN960JD516	Washer

batch

M109059 ✓

PL08.12.05 SP

12.0

CP21

1/8" Cotter Pin 2" long



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
pick:

qty	Part Number	Description
2	CP21	1/8" Cotter Pin 2" long

batch

M16626 ✓

M108200 ✓ SP

13.0

MS21042L5

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
pick:

qty	Part Number	Description
1	MS21042L5	Nut

batch

M108161 ✓

PL08.12.05 SP

14.0

SNF34

SLOTTED NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
pick:

qty	Part Number	Description
1	SNF-34	SLOTTED NUT

batch

M102395 ✓

8/10/05

SP

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Seq. #:

Machine Or Operation:

Description:

15.0

TP2

Inventory



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

pick:

qty	Part Number	Description
1	TP-2	Spring pin

batch

M16588 ✓

PL08-12-05

16.0

TP134

Inventory



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

qty	Part Number	Description
1	TP-134	Spring pin

batch

16362 ✓

8/10/15

17.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Assemble as per dwg DSK 093

2-Grease fitting 113-800, apply LPS C30316 on all parts areas not protected by paint or grease.

PL08-12-05

(X1)

18.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

50062605 (X0)

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PPP 42461

PL08-12-05

20.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/12/09

Job Completion



MF 08-12-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

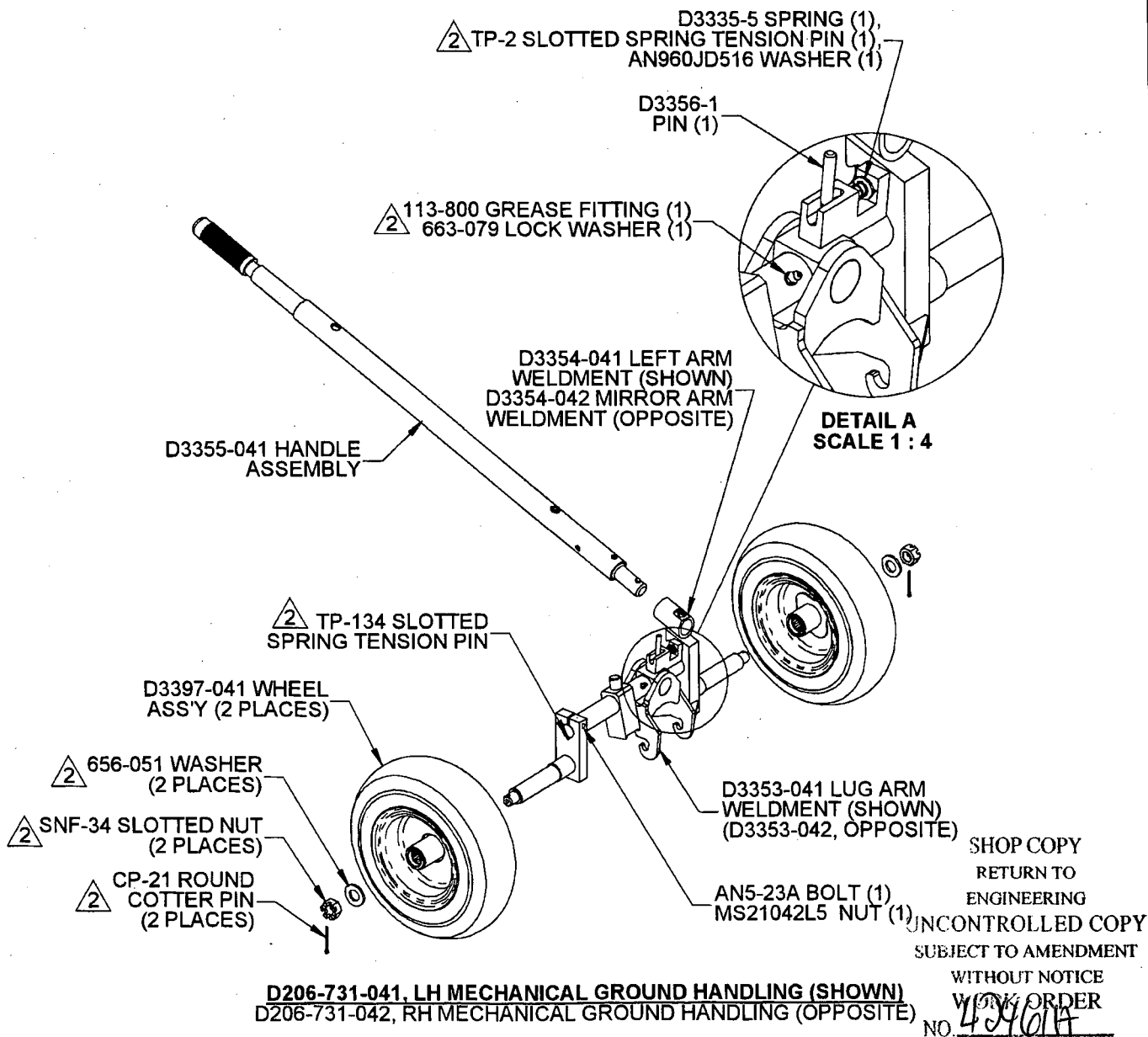
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART**RELEASED**
11h 07.02.05

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DSK 093	REV. B SHEET 1 OF 1
DATE 07.02.02	TITLE MECH. GROUND HANDLING		SCALE 1:10
REV	DATE	DESCRIPTION	
A	05.02.10	NEW ISSUE	
B	07.02.02	REDRAWN	

**NOTE:**

- 1) APPLY RUST INHIBITOR ON ALL PARTS AND AREAS NOT PROTECTED BY PAINT OR GREASE.
RUST INHIBITOR POSSIBLE SUPPLIER: ACKLANDS-GRANGER INC., P/N LPSC30316.
- 2) SUPPLIER: SPAENAUR.

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